



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4577-1

Job Sheet 180695



Part No: D4577-1

Job Qty: 4 ea

Part Name: Rear Access Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 2 IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC IPP REV:B 12.04.25 AS PER DWG
REV.B DD VERF:EC IPP REV:C 15.01.15 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	7/31/18	7/31/18	0.00	0.00	Start Up Waterjet		8/07/17
100	Waterjet	4 pcs	7/31/18	7/31/18	0.03	0.57	Waterjet1		8/07/17
120	QC	4 pcs	7/31/18	7/31/18	0.00	0.00	QC8		38
150	HandFinish	4 pcs	7/31/18	7/31/18	0.00	0.55	HandFinish1		38
160	QC	4 pcs	7/31/18	7/31/18	0.00	0.00	QC7		38
190	Packaging	4 pcs	7/31/18	7/31/18	0.00	0.00	Packaging3		38
200	QC21-SA	4 Ea	7/31/18	7/31/18	0.00	0.00	QC21		21

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	3.3600 sf (.84 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.125	3	85	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Rear Access Panel	0.206Inches + 0.005 - 0.001	0.211 0.205	0.207	Diameter
2	Rear Access Panel	0.630Inches ± 0.030	0.660 0.600	0.638	
3	Rear Access Panel	3.770Inches ± 0.030	3.800 3.740	3.777	
4	Rear Access Panel	10.500Inches ± 0.030	10.530 10.470	10.500	
5	Rear Access Panel	0.125Inches ± 0.010	0.135 0.115	0.125	

Plex 7/12/18 7:35 AM Dart.lajeunesse.marie



Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐	Engineering ☐
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐	Quality ☐
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐	Other ☐
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐	
Date : _____	Step #: _____	QTY Effective : _____							
Description Work Order Deviation		42) Approval _____ leted By _____ / Supervisor /erification _____ Coordinator oval _____ I Wrong mensions er tolerance art incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
		Part: D4577-1 Job No: 180695 Serial No/Batch: S092464 Container No: S092464 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/17/18							
Root Cause		Dart Aerospace Ltd. 1270 Aberdeen Street Haverhill, ON K6A 1K7 CANADA TEL: 1 813 632-8200 Email: sales@dartaero.com www.dartaero.com							
Environment ☐	No Re-verification ☐	Pressure/Force ☐		Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Design ☐	Operator ☐	Bending ☐		Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Con ☐		Countersink ☐	Off-set ☐	Drawing ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐		Cut Too Short ☐	Mislabeled ☐	Finish ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/wave ☐		Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Material ☐	Use for Testing ☐	Cuffs ☐		Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐							
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐							
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐							
Substation ☐	Process Improvement ☐	Marks/Chatter ☐							
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							